

Work Order ID 50287

July 14, 2009 11:39:55 AM

Page 1

Item ID: D3502-1

Accept

Revision ID: B

Item Name: Support

Start Date: 7/15/09 Start Qty: 20.00

Required Date: 7/15/09 Req'd Qty: 20.00

Reference:

09.07.16

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3502	Rev B

100



Bandsaw

Jcaspa Bandsaw

BAND SAW

Memo

Cut blank 3.475 " long ☐ BLANK MAKES 2 PARTS

0.00

0.00

DIP 8/6/19

20

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Mill as per Folio FA649 Rev: *AA* & Dwg D3502 Rev: *B* 12-Deburr

0.00

0.00

DIP 8/6/20

38

2

PTO

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DIP 8/6/20


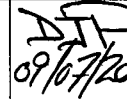
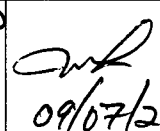
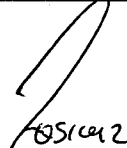
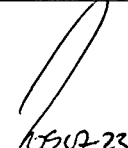


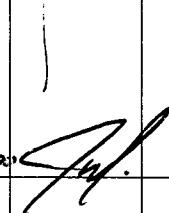
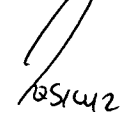
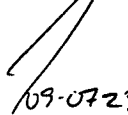
38

0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3502-1 PAR #: N/A Fault Category: Prod. Eng. Coord NCR: Yes No DQA: NA Date: 09.08.05
Scrap / Scrap QA: N/C Closed: 7 Date: 09.08.19

NCR: <u>50287</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/07/20	110	1 part jumped out of "Vise" during 2 nd operation. Vise was not tightened enough, to avoid flexing the part. Folio stated to place the part 0.240" deep into the vise, but that is too deep. Part should only be in 0.200" deep to avoid machining the vise.		Scrap and destroy no replace. Update the 0.240" dim on the Circo. (J.L.M) and attach the revision.	 09/07/20	 09/07/23		
		QC: process.		 Modify Set-up Sheet				

NOTE: Date & initial all entries

Work Order ID 50287

July 14, 2009 11:39:55 AM

Page 2

Item ID: D3502-1

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Item Name: Support

Start Date: 7/15/09

Start Qty: 20.00

Required Date: 7/15/09

Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

mf 09/07/23

38

0

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Mark hole position using DT9430 Drill as per Dwg D3502.

EP 09/07/27 (38)

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BL 09-07-27 (38)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50287

July 14, 2009 11:39:55 AM



Page 3

Item ID: D3502-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Support

Start Date: 7/15/09

Start Qty: 20.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 112148.

Memo

0.00

START TIME:

9:15

3:20 FINISH TIME:

OVEN TEMPERATURE:

9:45.

BA 09-07-28 (38).

Powder Coating

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

HL 09-07-28 (38)

Quality Control

180

Identify as per dwg & Stock Location: *168*

0.00



Packaging

Memo

0.00

9/17/28 (38x) SQ

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50287

July 14, 2009 11:39:55 AM



Page 4

Item ID: D3502-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Support

Start Date: 7/15/09

Start Qty: 20.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw Plan
Rev. Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/29

WF 09-07-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

July 14, 2009 11:39:54 AM

Work Order ID: 50287

Parent Item: D3502-1RevB

Parent Item Name: Support

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	74.3000	6.0842			



6061-T6 Bar 1.00 x 4.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

74.3

107221

62.27

11941

12.03

Signature
09/07/18

M 8803.

6.0842 x 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

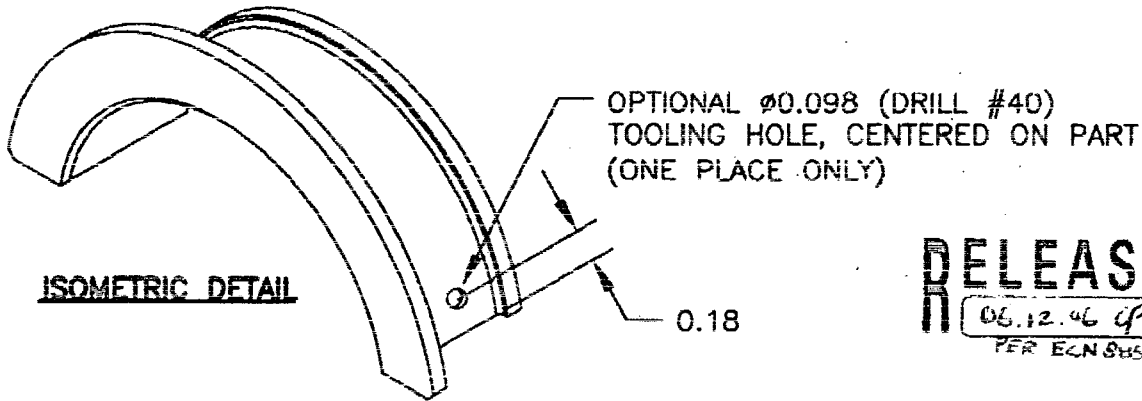
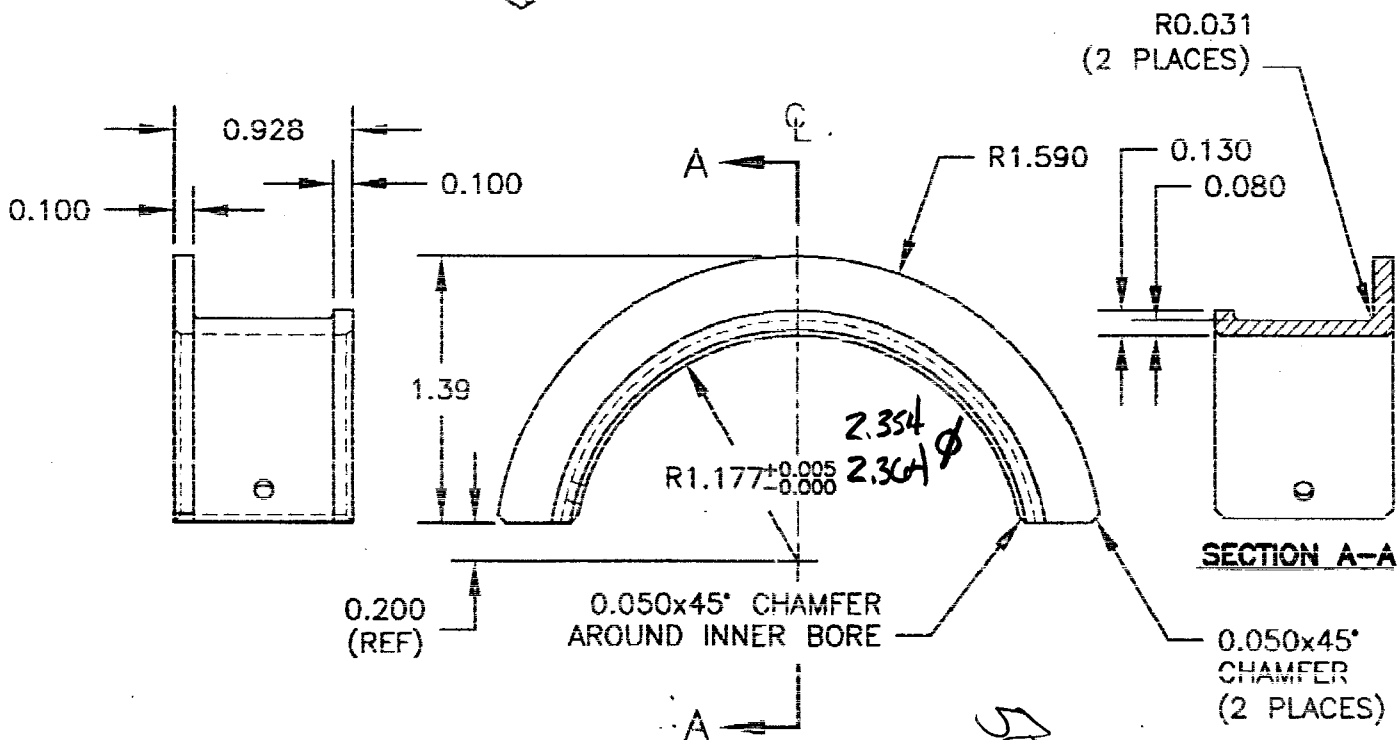
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31		TITLE SUPPORT	SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	

ISOMETRIC DETAIL**RELEASED**
06.12.46 *qp*
PER ECN 885

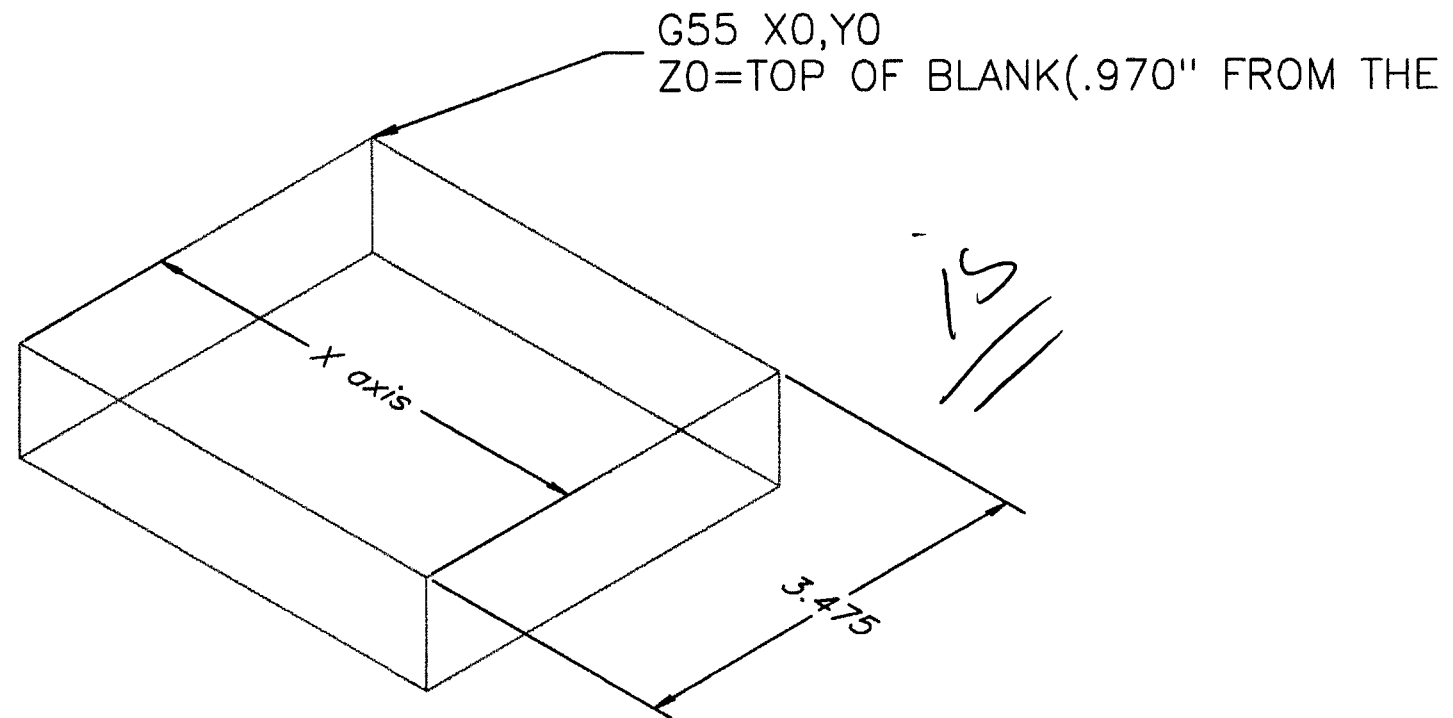
D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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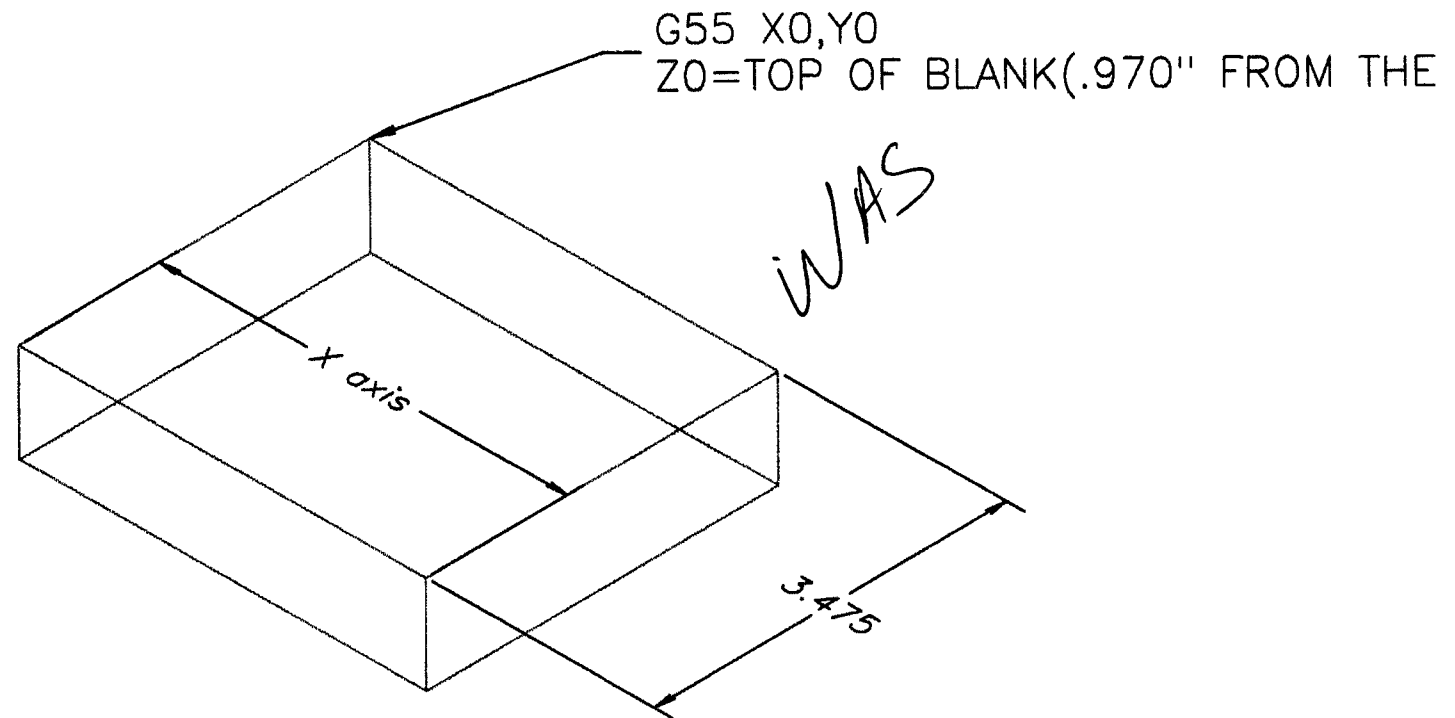
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2ND OP. PROG 2000



FACED SIDE FACING DOWN IN VISE
HOLD BY MAX. 0.200"

2ND OP. PROG 2000



FACED SIDE FACING DOWN IN VISE
HOLD BY MAX. 0.240"